



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18520-5
Job Sheet 193885



Part No: RBT18520-5

Job Qty: 4 pcs

Part Name: Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/24/19

Job Tracking No:

Due Date: 5/31/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18520 Rev Q IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP/IPP Rev. B 19.02.22 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup	Run		
					Hrs	Hrs	Workcenter / Supplier Lead Time	
100	Large Fab - Welded Assy-1	4 pcs	5/31/19		0.00	0.67	Large Fab - 1	
							Large Fab - 10	
							Large Fab - 2	MLV
							Large Fab - 3	MLV
							Large Fab - 4	
							Large Fab - 5	
							Large Fab - 6	
							Large Fab - 7	
							Large Fab - 8	
							Large Fab - 9	
110	QC 9	4 pcs	5/31/19		0.00	0.00	QC 9 - 10	
							QC 9 - 18	
							QC 9 - 24	
							QC 9 - 43	
							QC 9 - 50	EL
							QC 9 - 9	
115	QC 5	4 pcs	5/31/19		0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S194300



Part: RBT18520-5

Job No: 193885

Serial No/Batch: S194300

Revision: Q

Inspector:

Exp Date:

Instructions:

Date: 06/27/19

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				QC 5 - 50		EL
				QC 5 - 30		
				QC 5 - 40		
130	Outsource - 12 - Black Oxide	4 pcs	5/31/19	GRO002-VC	10	HY 2019-06-27
140	Packaging 2-1 - Receive - B4B	4 pcs	5/31/19	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	DP JUL 03 2019
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
150	QC 6	4 pcs	5/31/19	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	61
						9-89
160	Packaging 3-1 - Stock - B4B	4 pcs	5/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	

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					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
170 QC 21 - SA	4 pcs	5/31/19	0.00 0.00	QC 21 - SA - 21		
				QC 21 - SA - 70	DAS	
				QC 21 - SA - 53	21 9-85	

GA145B

JUL 05 2019

Part Op 100 - Weld as per drawing.

Descriptions: 110 - QC9- Inspect visual per QSI004- Fusion Welds

130 - -Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required

140 - Receive & Inspect for Damage & Mat'l Certs

150 - QC6- All purchased or subcontracted products

160 - Identify as per dwg & Stock Location: _____

170 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBT18520-3	Top Bolt Tab	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5106812
RBT18520-5A	Top Bolt	4 pcs (1 ea)	100-Large Fab - Welded Assy-1	5106251

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Welded Assy-1	RBT18520-3	4	16	0
	RBT18520-5A	4	8	0

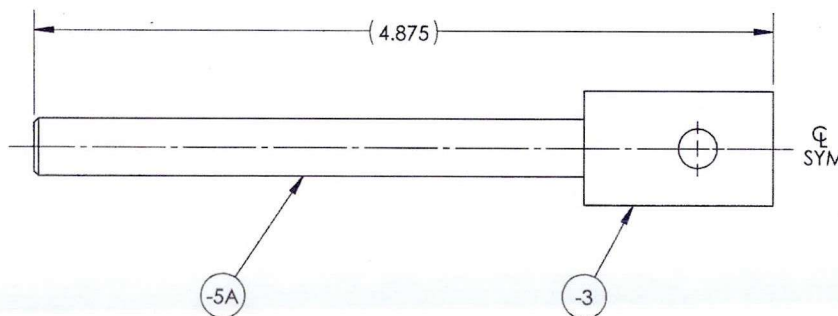
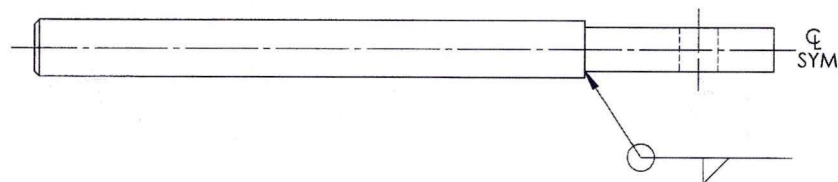
Part Specifications

Specifications could not be found.

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REVISIONS				DATE	INITIAL	APPROVED
REV	ECR	DESCRIPTION				
Q		WELDING SYMBOL CORRECTED, CL SYM ADDED, SPEC FOR FINISH CHANGED		2/19/2019	VM	VM



(5)
TOP BOLT WELDMENT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193885 MLC
190424



TITLE
M/R DAMPER LOAD TEST DEVICE

DWG NO. RBT18520-5 REV Q

MAT'L		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 1°	
DRAWN BY: COLE		X ± .1 SURFACES = 125/✓	
CHECKED: MACKOVJAK		1. BREAK ALL SHARP EDGES	
OPPS APPR: ANDERSON		.015 x 45° OR .015R	
QA APPR: LINDSAY		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
APPROVED: VLP		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
SCALE		USED ON MODEL	
N/A		DATE 8/17/2000	
		SHEET 4 OF 17	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS			
		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☐ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐
Date :	Sequence #:	QTY Affected :			MRB (QS1042)
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor
					QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled	☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up	☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread
		Other/Details:			



Dart Aerospace Ltd.
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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB043865



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB043865

PO Date: 6/27/19

Due Date: 7/5/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Phone:

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2019-06-28

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	194546	RBE350A94-2706-00-07	Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/5/19	20 pcs	0 pcs	20 pcs	\$3.75/pcs	\$75.00
2	196621	RBEL133M-6201-101-21	Base -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	7/5/19	4 pcs	0 pcs	4 pcs	\$3.75/pcs	\$15.00
3	193885	RBT18520-5	Weldment -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	7/5/19	4 pcs	0 pcs	4 pcs	\$3.75/pcs	\$15.00

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PURCHASE ORDER

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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	193886	RBT18520-7	Pivot Bar Weldment -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; Steel -Certificate of Conformity is required	Firmed	-	7/5/19	4 pcs	0 pcs	4 pcs	\$3.75/pcs	\$15.00
Grand Total:											\$120.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 6/28/19 11:03 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(020382-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.grouppaltech.com

Bon de Livraison / Packing Slip

020382- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
03-Jul-2019		SVETLANA DORZHIYEVA		POHB043865				
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
2	RBEL133M-6201-101-21 Rev.	RBEL133M-6201-101-21 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0
3	RBT18520-5 Rev.	RBT18520-5 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	4	4	0	0	0
4	RBT18520-7 Rev.	RBT18520-7 OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE 3 OR MILL-C23411A OR MIL-PRF-81309 WIPE OFF EXCESS	OXIDE-BLACK CH	4	4	0	0	0

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Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.